



Date: Thursday, 22/03/2007 3:20:00 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CONSOLE SIDE LH (206 HI-SLOPE)
<b>Job Number</b> : 31332	
<b>Estimate Number</b> : 11000	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D26021
<b>This Issue</b> : 22/03/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2602 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 31332	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 10/04/2007 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est. D 04.02.25 Reformat KJ/RF	
Note: Issue with part number D2602-2	
Est Rev:E Now On Waterjet 07-03-22 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



**Comment:** Qty.: 1.4146 sf(s)/Unit Total : 14.1456 sf(s)  
 2024-T3 .040 sheet  
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
 (M2024T3S.040) Batch M104025

SAD 07/04/14

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D2602  
 \*\*\*\*\*Same Cutting File for -1 & -2 \*\*\*\*\*  
 Dwg Rev: A1  
 Prog Rev: A1

2-Deburr if necessary

SAD 07/04/14 (10)  
SAD 07/04/24 60

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/04/14 (10)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

SAD 07/04/14 (10)

Date: Thursday, 22/03/2007 3:20:00 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 31332

Part Number: D26021

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

SAD 07/04/24 (10)

Form as per Dwg D2602

SB 07/05/03

(10)

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/05/04 (10)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 07-05-04

10

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07/05/04 (10)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

FF 07-05-04

10

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/07

(10)

Job Completion














U 07/05/04

Date: Tuesday, 3/20/2007 12:03:28 PM  
User: Kim Johnston

# **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)
Job Number	: 31333		
Estimate Number	: 11001		
P.O. Number	:	Part Number	: D26022
This Issue	: 3/20/2007 S.O. No. :	Drawing Number	: D2602 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 25472	Material	:
Written By	:	Due Date	: 4/10/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>4/07.03.20</u>		
Comment	: Est. E 04.02.25 Reformat KJ/RF		
	Note: Issue with part number D2602-1		

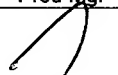

## **Additional Product**

Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
			
Comment:	Qty.: 1.4146 sf(s)/Unit Total : 14.1456 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch _____		
2.0	SHEAR	SHEAR	
			
Comment:	SHEAR Cut Blank per template DT8243		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment:	HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA145 and Dwg D2602 Stack of 10 Identify as D2602-2		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK	
			
Comment:	SECOND CHECK		




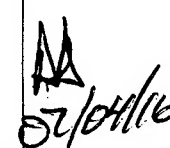
*W. H. Taylor*

*(10)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/04/16	2.0	Add a grain direction to the bag <sup>or w/o</sup> <del>along</del> opposite to 13.699". Permanent change				 07/04/16	 07/04/16	

Part No: D2602-2 PAR #: N/A Fault Category: Prod/PAB ASS. MED 1501 NCR: Yes No DQA: P Date: 07/05/07  
QA: N/C Closed: P Date: 07/05/08

NCR: <u>31333</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/04/14	2.0	Hole's were to big because Jet offset was at 0.022" suppose to be at 0.015" Program fault 1 SCRAP	 05/10/12	Scrap & destroy, Replace	SAD 07/04/14	 07/04/16	 05/10/12	 07/04/16

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 12:03:28 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 31333

Part Number: D26022

Job Number:



Seq. #

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

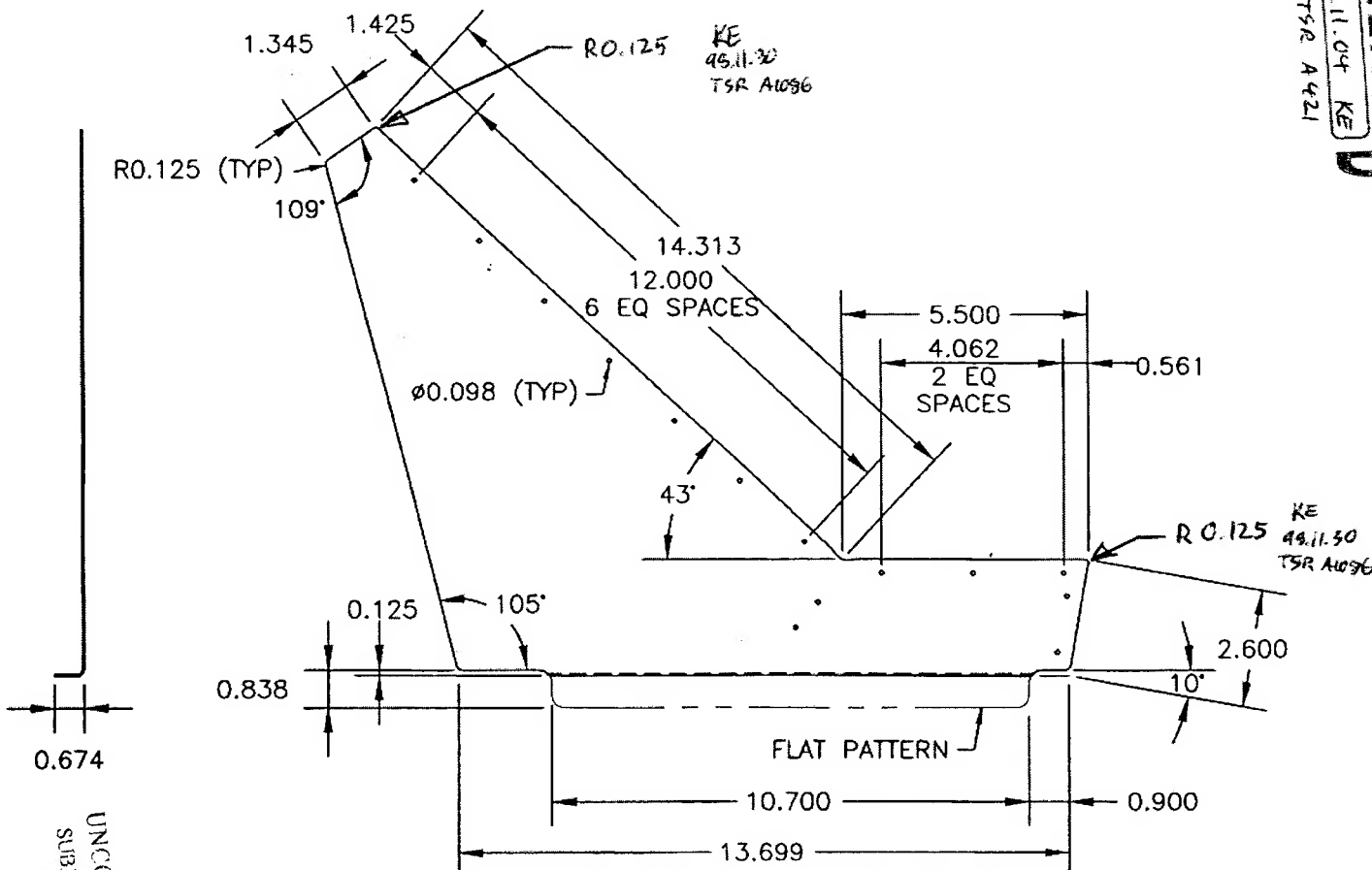
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****RELEASED**  
97.11.04 KE  
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED KE	APPROVED Bw	DRAWING NO. D2602	REV. A
DATE 97.10.22		TITLE CONSOLE SIDE	SHEET 1 OF 1
			SCALE 1:4
A	97.10.22	D2602 WAS D206-547-21/	
AI	02.06.04	ADD FINISH	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK  
PROFILE CONTROLLED BY FOLIO H2602  
BEND RADIUS 0.093  
FINISH: CHEMICAL CONVERSION COAT PER PART QSI 605 4.1 **AI**  
D2602-1 SHOWN  
D2602-2 OPPOSITE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 313333





